



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.4115
Job Sheet 168034



Part No: 647.4115

Job Qty: 10 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/24/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV N/C3 SHEET 5 IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/23/17	0.00	0.00	Start up container		SC 17/12/23
110	Waterjet	10 pcs		11/24/17	0.01	0.25	Waterjet1		SC 17/12/23
120	QC	10 pcs		11/24/17	0.00	0.00	QC2		SC 17/12/23
130	QC	10 pcs		11/24/17	0.00	0.00	QC8		38
140	Outsource	10 pcs		11/24/17			ATG001-VC		3-88
150	Packaging	10 pcs		11/24/17	0.00	0.00	Packaging2		DAS
160	QC	10 pcs		11/24/17	0.00	0.00	QC5		38
190	Packaging	10 pcs		11/24/17	0.00	0.00	Packaging3	CK 112	AP 18/10/24
200	QC21-SA	10 Ea		11/24/17	0.00	0.00	QC21		

Part Op 110 - 1-Cut as per Dwg

Descriptions: 140 - Issue P/O to ATG : _____

190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.090 123287	0.2	42	0	0

Part Specifications

Specifications could not be found.

Plex 11/10/17 11:17 AM dart.lacelle.linda

DART
AEROSPACE

S026933

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Shim

PART NO: 647.4115

Original Serial #: S026933

Revision:

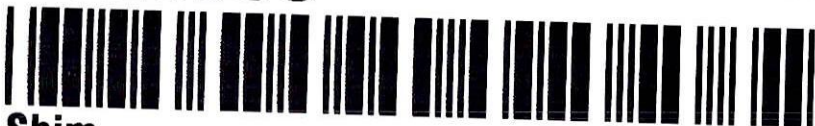
Operation: Outsource

Change No:

Mfg Date: 12/23/17
Job No: 168034

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K64 1K
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.c
www.dartaerospace.com

DART
AEROSPACE
S026933



Shim

647.4115

Start up Operation

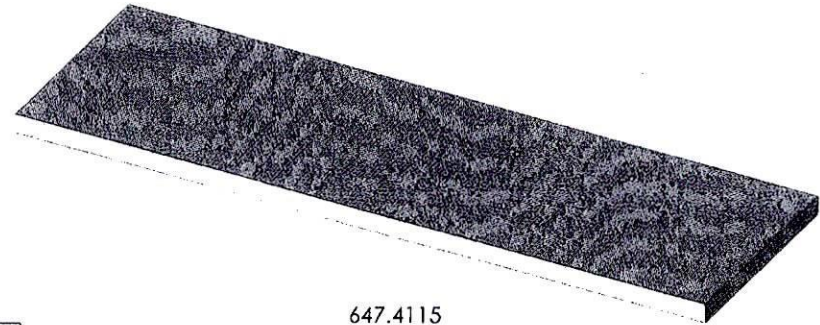
Mfg Date: 12/23/17
Job No: 168034

PART NO:
Revision:
Operation:
Change No:

QA Closed: _____		Date: _____		Work Order update only ☐		
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS		
		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____		Step #: _____		QTY Effective : _____		
Description Work Order Deviation		Disposition		MRB (QSI042) Approval		
				Completed By		
				Lead hand / Supervisor Approval Verification		
				QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY				
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabelled	☐ Finish	
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____				
Misidentified ☐	☐ Past Due					

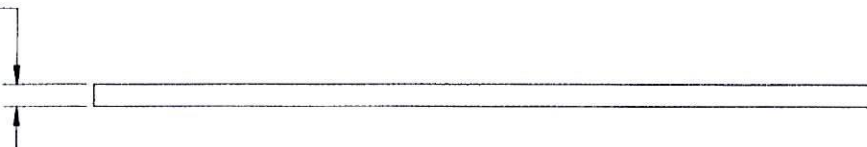
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

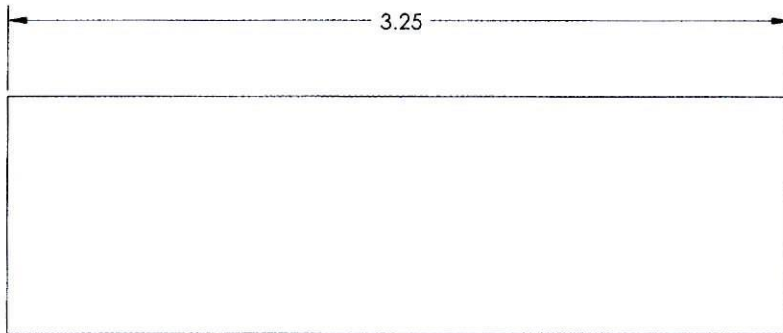


647.4115

.090



3.25



.984

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168034

DAS
30
9-89

NOV 13 2017

DESIGNED BY: _____ DRAWN BY: _____ CHECKED BY: _____ ENGINEER: _____ DATE: _____ PROJECT: _____ CONTRACT: _____	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
SHEETMETAL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS: .001 ANGLES: .5°	SIZE: 1/2" X 3/4" X .001 B: 07M26	DWG. NO: 647.4100	REV: N/C
SCALE: NONE		SHEET: 5 OF 6	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914460

Date: 22-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613-632-9377 Fax: 613-632-1551

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 647.4115 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22300		Rev: N/C PO: PO038727 Line: 10
10 ea	Part: 647.7913 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22301		Rev: A PO: PO038727 Line: 11
12 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22305		Rev: A PO: PO038727 Line: 15
10 ea	Part: 646.3811 Radius Block Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22306		Rev: A PO: PO038727 Line: 16
10 ea	Part: 647.4114 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22307		Rev: N/C PO: PO038727 Line: 17
Made in Canada			



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038727

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	168031	647.3916	Splice Plate Issue P/O _____ATG, black anodize and prime as per dwg 647.1612 Rev. A	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$18.80/pcs	\$37.60
9	168033	647.4114	Deflector Issue P/O to ATG : Hard Anodize Color Black, Prime as per Dwg 647.3900 Rev. C	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$6.95/pcs	\$69.50
10	168034	647.4115	Shim Issue P/O _____ATG, black anodize and prime as per dwg 647.4114 Rev. N/C	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$6.95/pcs	\$69.50
11	169394	647.7913	Shim Issue P/O _____ATG, black anodize and prime as per dwg 647.4115 Rev. N/C	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$8.10/pcs	\$81.00
12	168215	646.2910	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 647.7913 Rev. A	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$48.70/pcs	\$97.40
13	168247	646.3717	Deflector Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	1/30/17	20 pcs	0 pcs	20 pcs	\$6.95/pcs	\$139.00
14	168248	646.3718	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 646.3717 Rev. A	Firmed	1/30/17	40 pcs	0 pcs	40 pcs	\$4.65/pcs	\$186.00
15	168249	646.3719	Custom Washer Issue P/O _____ATG, black anodize and prime as per dwg 646.3718 Rev. A	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$6.95/pcs	\$83.40
16	168251	646.3811	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 646.3719 Rev. A	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$7.25/pcs	\$72.50
17	168228	646.3312	Radius Block Issue P/O ATG, black anodize and prime as per dwg 646.3811 Rev. A	Firmed	1/30/17	8 pcs	0 pcs	8 pcs	\$12.75/pcs	\$102.00
			Center Plate Issue P/O to ATG : _____	Firmed	1/30/17	8 pcs	0 pcs	8 pcs	\$12.75/pcs	\$102.00